

Work Order ID 56357

February 19, 2010 7:59:43 AM



Page 1

Item ID: D4042-041

Accept



Setup Start



Revision ID:

Item Name: Short Basket Base Assembly, LH

Stop



Start Date: 2/19/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/23/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4042

A

100

Weld per dwg A/R S.S. rod Batch: M109215 0.00

Large Fab

Memo

0.00

PD 10.02.23

Large Fab

1- assemble ribs , handel plates weld as per dwg D4042

inspect before welding mesh

2- tack weld mesh on basket as per dwg D4042 (trim mesh if necessary)

3- weld hinges, and Mounting brackets as per dwg D4042

take lid to locate hinge and bracket

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

PL 10.02.24

Work Order ID 56357

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Page 2

Item ID: D4042-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Base Assembly, LH

Start Date: 2/19/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/23/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

8/10/24

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

PRESSURE - WASH

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

M113170

Memo

0.00

→ 10/02/24

0.00

(X) ✓

→ Plug holes prior to

1ST COAT:

START TIME: 10:30AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 11:00AM

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 11:15AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 11:45AM

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Page 3

Item ID: D4042-041

Accept



Setup Start



Revision ID:

Item Name: Short Basket Base Assembly, LH

Stop



Start Date: 2/19/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/23/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

140



QC

Quality Control

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

150



HandFinish

Hand Finishing

Assemble as per dwg

0.00

Memo

0.00

160



QC

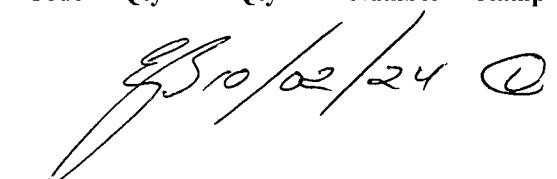
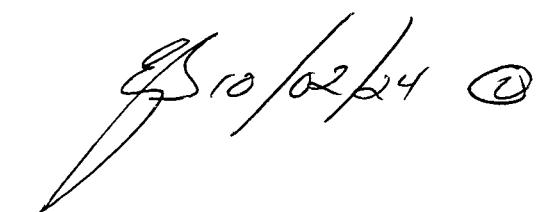
Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00



Work Order ID 56357

February 19, 2010 7:59:49 AM



Page 4

Item ID: D4042-041

Accept



Setup Start



Revision ID:

Item Name: Short Basket Base Assembly, LH

Stop



Start Date: 2/19/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/23/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: G-A

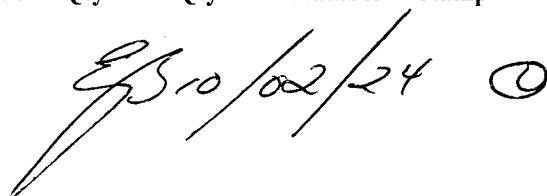
0.00



Packaging

Memo

0.00



180

QC21- Final Inspection - Work Order Release

0.00

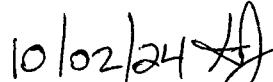


QC

Memo

0.00

Quality Control



MF

10-2-24

Picklist Print

February 19, 2010 7:59:20 AM

Page 1

Work Order ID: 56357



Parent Item: D4042-041



Parent Item Name: Short Basket Base Assembly, LH

Start Date: 2/19/10

Required Date: 2/23/10

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4042-043		Manufactured	No			100	Each	0.0000	1.0000			

Aft Rib Assembly

D4043-041		Manufactured	No			100	Each	1.0000	1.0000		
-----------	--	--------------	----	--	--	-----	------	--------	--------	--	--

Rib Assembly

Warehouse	Loc Qty	Loc Code	Location	
			Main Warehouse	
WA	1		56013	
	1			
			100	Each
			4.0000	2.0000

D4044-043



Center Rib Assembly

Warehouse	Loc Qty	Loc Code	Location	
			Main Warehouse	
WA	4		56037	
	2		56173	
	2			
			100	Each
			2.0000	1.0000

D4044-041



Fwd Rib Assembly

Warehouse	Loc Qty	Loc Code	Location	
			Main Warehouse	
WA	2		56017	
	1		56172	
	1			
			100	Each
			2.0000	1.0000

8 B56161 PD 10.02.19

B56163 PD 10.02.19

PD 10.02.19

PD 10.02.19

Picklist Print

February 19, 2010 7:59:21 AM

Page 3

Work Order ID: 56357



Parent Item: D4042-041



Parent Item Name: Short Basket Base Assembly, LH

Start Date: 2/19/10

Required Date: 2/23/10

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4042-9		Manufactured	No			100	Each	1.0000	1.0000			



Rib

B56167

PD 10.02.19

Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

1

56009

1

D4042-13



Rib

Manufactured

No

100

Each

1.0000

1.0000



B56164

PD 10.02.19

Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

1

56008

1

D4043-3



Rib

Manufactured

No

100

Each

1.0000

1.0000



B56169

PD 10.02.19

Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

1

56011

1

Picklist Print

Page 4

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Work Order ID: 56357



Parent Item: D4042-041



Parent Item Name: Short Basket Base Assembly, LH

Start Date: 2/19/10

Required Date: 2/23/10

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4043-5		Manufactured	No			100	Each	2.0000	2.0000			



Rib

B56170 10.02.19

Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

PD

56035

2

56035

2

D4043-7

Manufactured

No

100

Each

2.0000

2.0000

Rib

B56171

PD 10.02.19

Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

PD

56036

2

56036

2

D4044-5

Manufactured

No

100

Each

2.0000

1.0000

Aft Rib



Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

PD

56012

2

56174

1

1

PD 10.02.19

Picklist Print

Page 5

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Work Order ID: 56357



Parent Item: D4042-041



Parent Item Name: Short Basket Base Assembly, LH

Start Date: 2/19/10

Required Date: 2/23/10

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4042-11		Manufactured	No			100	Each	1.0000	1.0000			
Rib										BS6163	PD 10.02	

Warehouse Location	Loc Qty		Loc Code					
	Main Warehouse	WA	1					
	56010	1						
D4045-1	Manufactured	No	100	Each	6.0000	3.0000		
Lug							BS6176	PD 10.02.22

Warehouse Location	Loc Qty		Loc Code					
	Main Warehouse	WA	6					
	56002	6						
D4046-1	Manufactured	No	100	Each	0.0000	1.0000		
Mesh Basket Base							BS6176	PD 10.02.23
D4046-3	Manufactured	No	100	Each	1.0000	1.0000		
Mesh Fwd End							BS6043	PD 10.02.23

Warehouse Location	Loc Qty		Loc Code	
	Main Warehouse	WA	1	
	56015	1		

February 19, 2010 7:59:21 AM

Shop Packet Print

Page 5

Picklist Print

Page 6

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Work Order ID: 56357



Parent Item: D4042-041



Parent Item Name: Short Basket Base Assembly, LH

Start Date: 2/19/10

Required Date: 2/23/10

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4046-5 		Manufactured	No			100	Each	1.0000	1.0000		BS64041	PD 10.02.23
Mesh Aft End												

Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

1

56016

1

D4016-1

Manufactured

No

100

Each

6.0000

3.0000

Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

6

56073

6

D4021-1

Manufactured

No

100

Each

11.0000

4.0000

Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

11

56044

11

Picklist Print

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Work Order ID: 56357



Parent Item: D4042-041



Parent Item Name: Short Basket Base Assembly, LH

Start Date: 2/19/10

Required Date: 2/23/10

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581 		Manufactured	No			100	Each	15.0000	2.0000			B55918 PD 10.02.23
Mounting Bracket												

Warehouse

Location

Main Warehouse

ST	12	
46086	2	
48428	1	
51120	2	
54862	7	

Main Warehouse

WA	3	
50872	1	
51745	2	

D2931



Manufactured No

150 Each 903.0000 2.0000



EP 10/02/24

Warehouse

Location

Main Warehouse

ST	903	
46064	903	

2

Picklist Print

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Work Order ID: 56357



Parent Item: D4042-041



Parent Item Name: Short Basket Base Assembly, LH

Start Date: 2/19/10

Required Date: 2/23/10

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8		Purchased	No			150	Each	622.0000	2.0000			



Washer

EP 10/02/24

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

MS20600-AD4W3



Cherry Rivets

Purchased

No

150

Each

2,339.000 2.0000



EP 10/02/24

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	622	
107091	9	
108335	11	
110382	48	
110917	3	
111578	58	
112385	493	
ST	2339	
102929	37	
104715	10	
106375	324	
107939	1000	
111636	968	

8

7

6

5

4

3

2

1

D

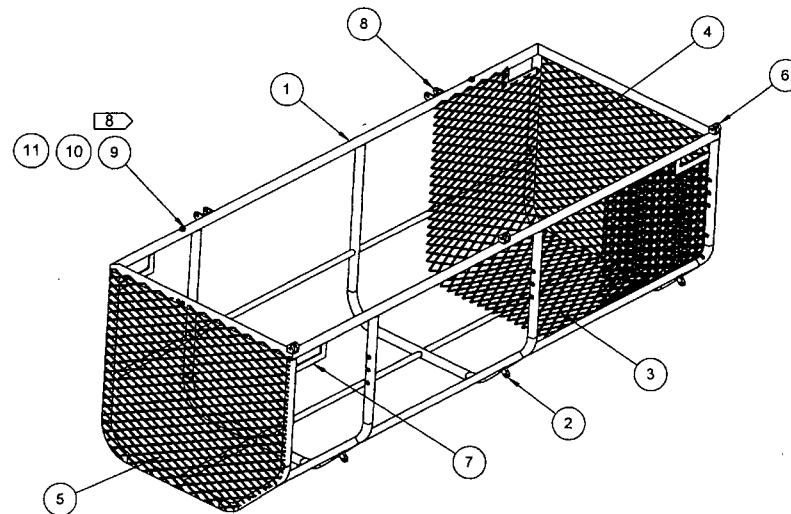
D

C

C

B

B



D4042-041 SHORT BASKET ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 28.82 lbs APROX
- 8) INSTALL AFTER FINISH
- 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
- 10) WELD PER DART QSI 004

ITEM	QTY	P/N	DESCRIPTION
	X	D4042-041	SHORT BASKET BASE ASSY, LH
1	1	D4042-101	BASKET BASE FRAME ASSY, LH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20600AD4W3	RIVET

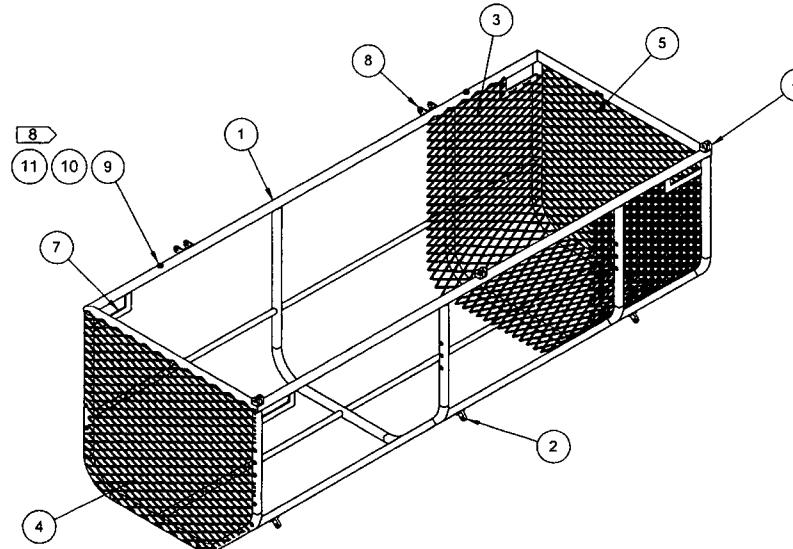
RELEASED
2010-02-16
MP

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	REV. A	
MFG. APPR.	RF	DRAWING NO. D4042	
APPROVED	RF	SHEET 1 OF 11	
DE APPR.	RF	TITLE: SCALE	
DATE	10.01.29	SHORT BASKET BASE ASSY NTS	

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8 7 6 5 4 3 2 1

ITEM	QTY -042	P/N	DESCRIPTION
	X	D4042-042	SHORT BASKET BASE ASSY, RH
1	1	D4042-102	BASKET BASE FRAME ASSY, RH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20600AD4W3	RIVET



RELEASED
2010-02-16
JW

D4042-042 SHORT BASKET ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

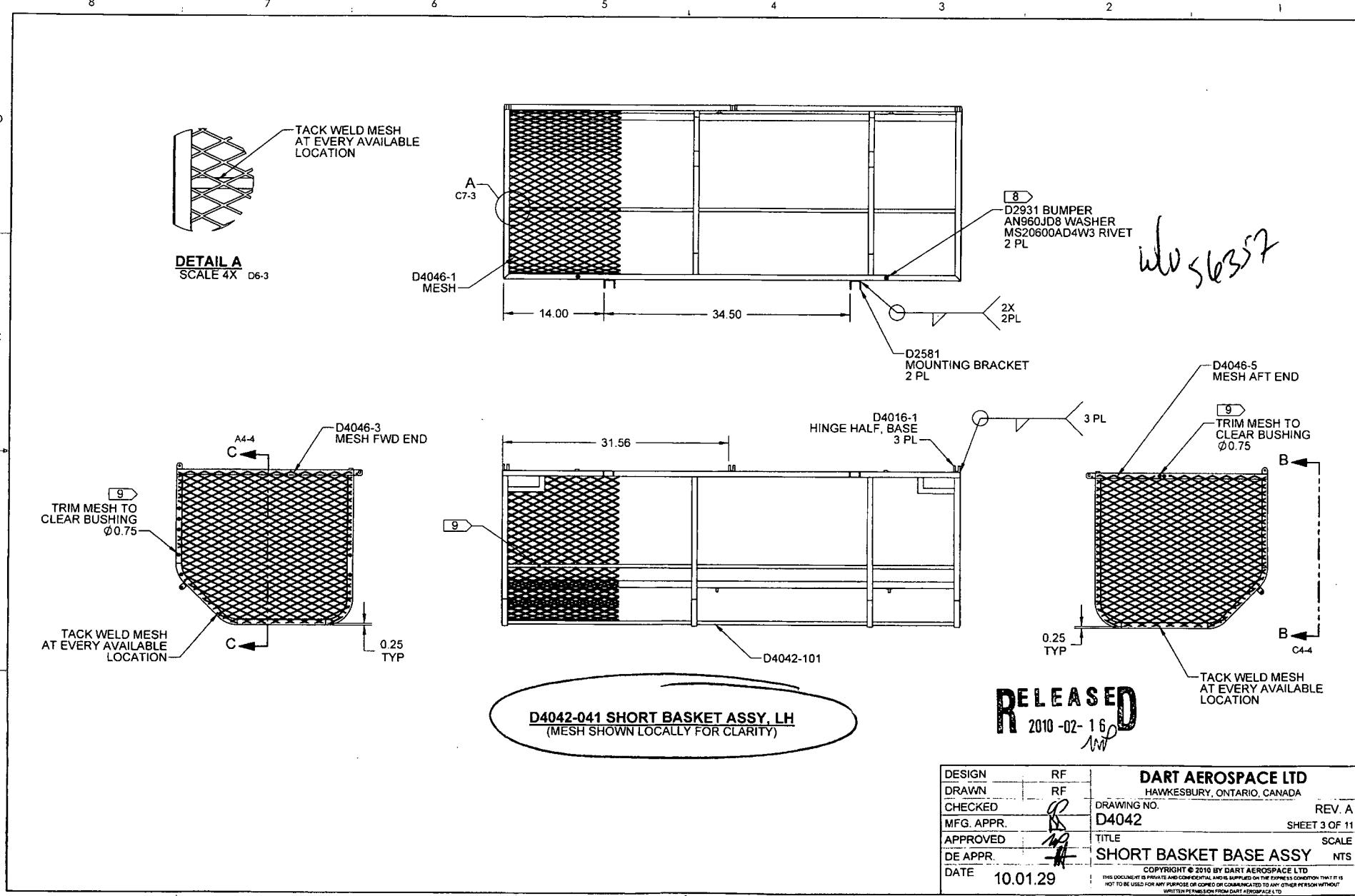
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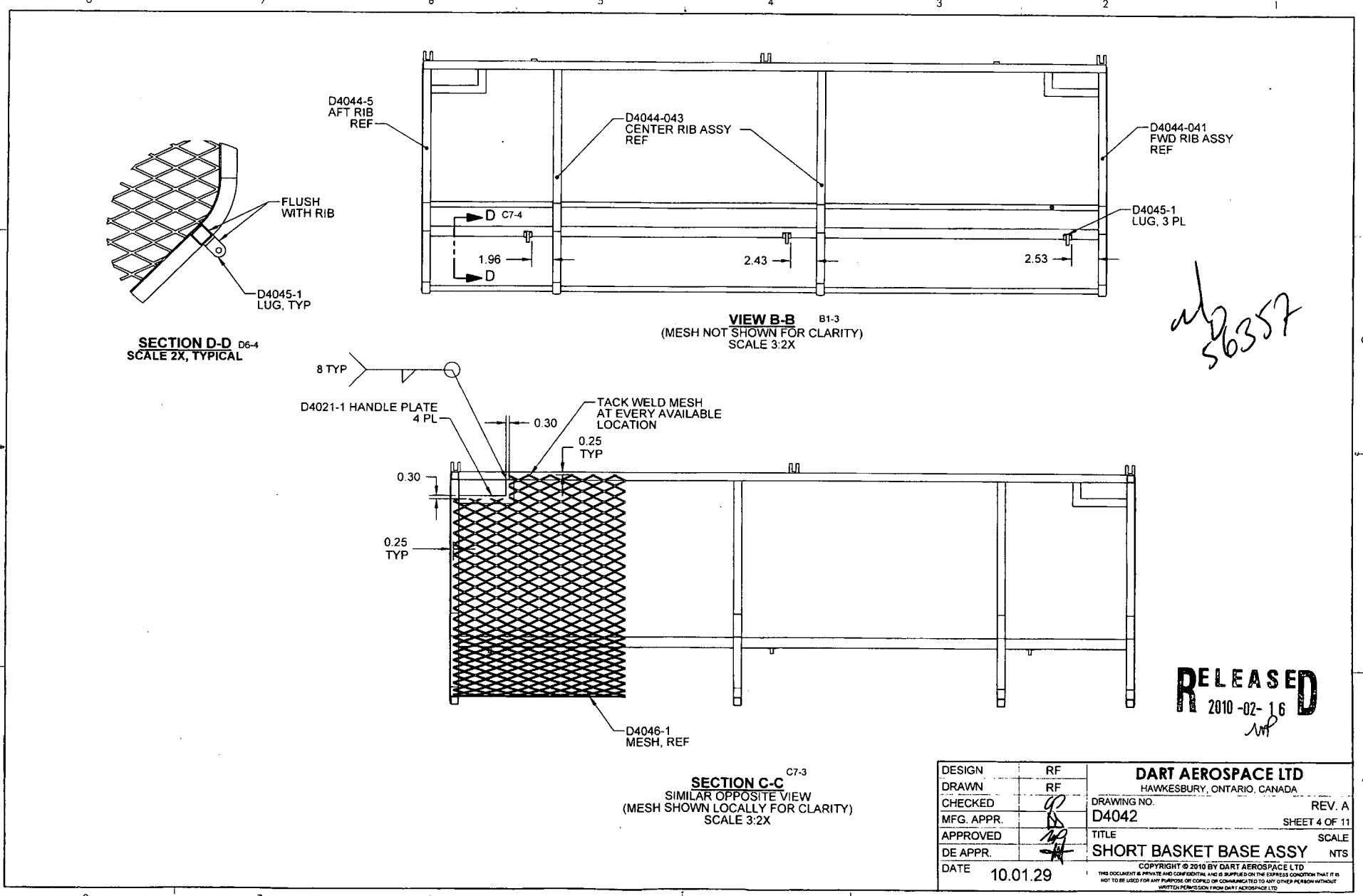
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 28.82 lbs APROX
- 8) INSTALL AFTER FINISH
- 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
- 10) WELD PER DART QSI 004

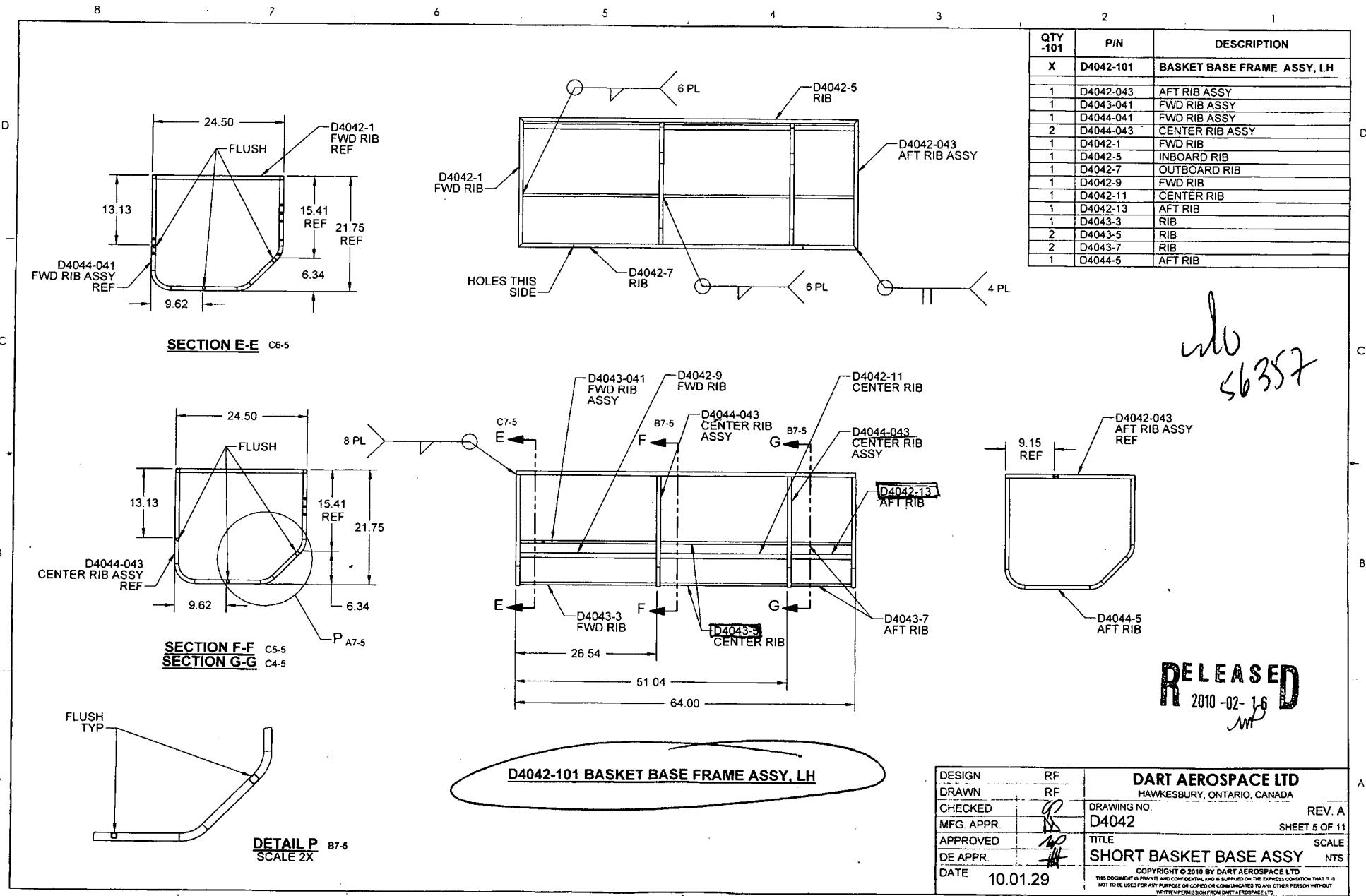
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>✓</i>	REV. A	
MFG. APPR.	<i>✓</i>	DRAWING NO.	D4042
APPROVED	<i>✓</i>	SHEET 2 OF 11	
DE APPR.	<i>✓</i>	TITLE	SHORT BASKET BASE ASSY
DATE	10.01.29	SCALE	NTS

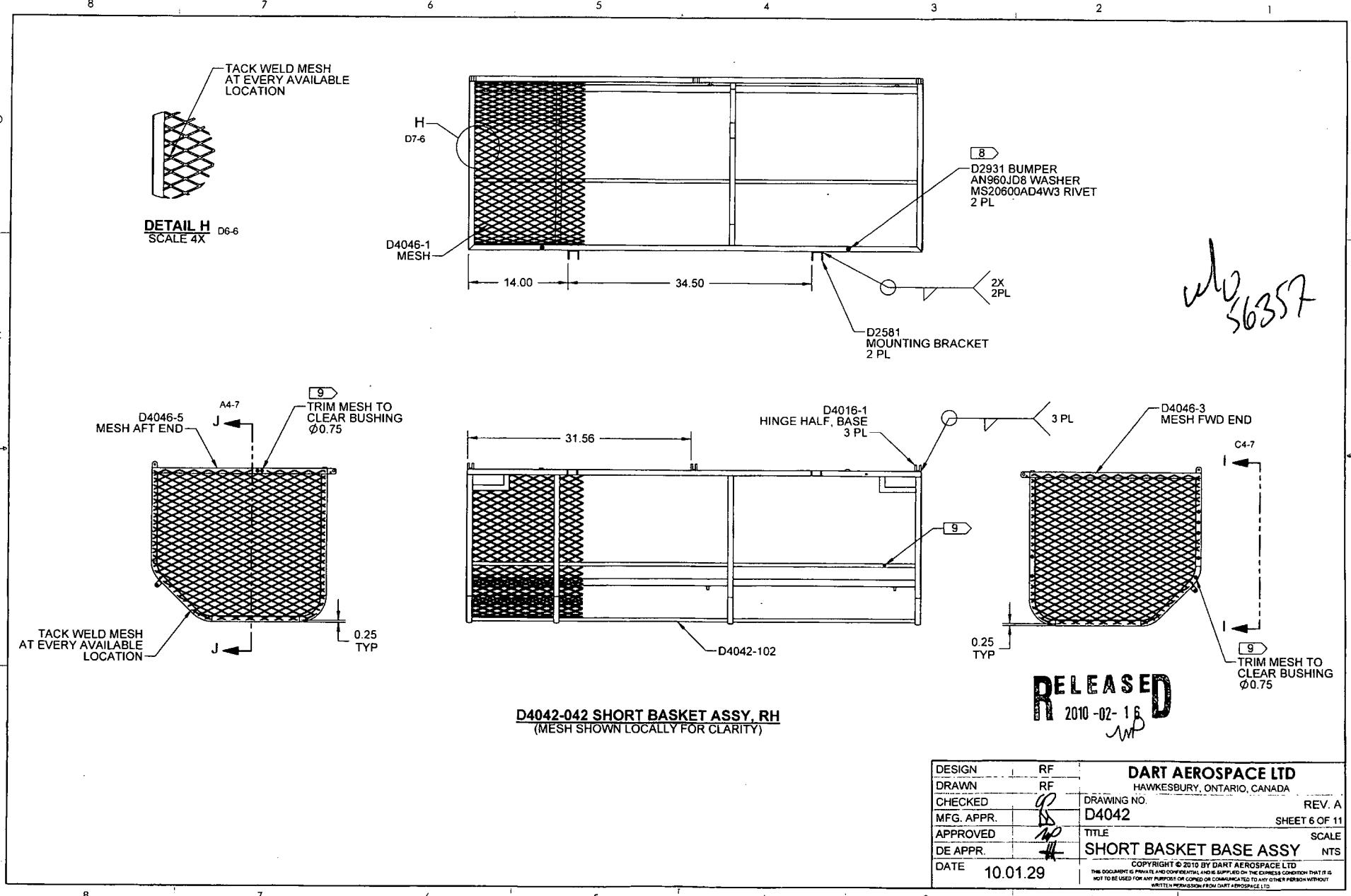
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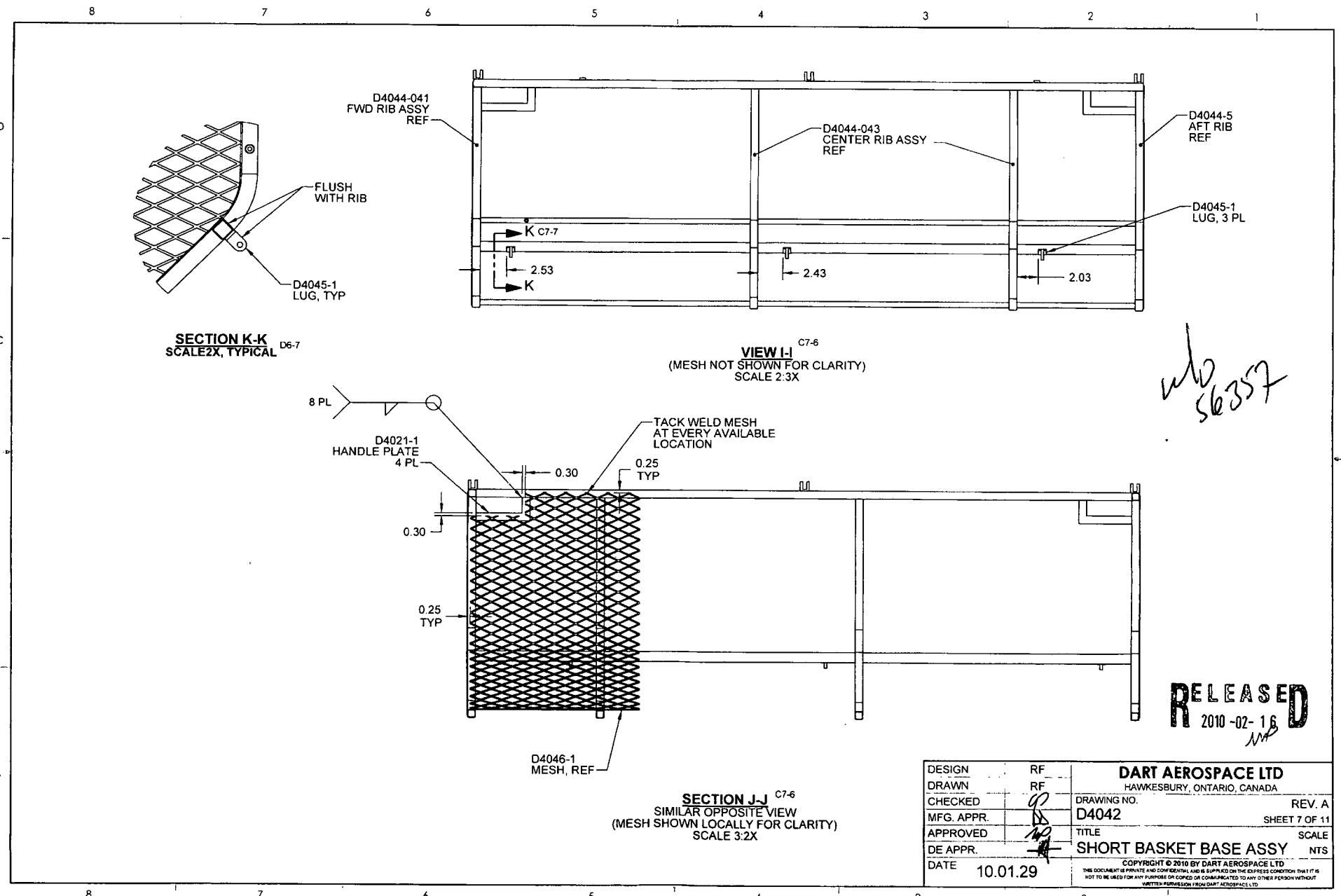
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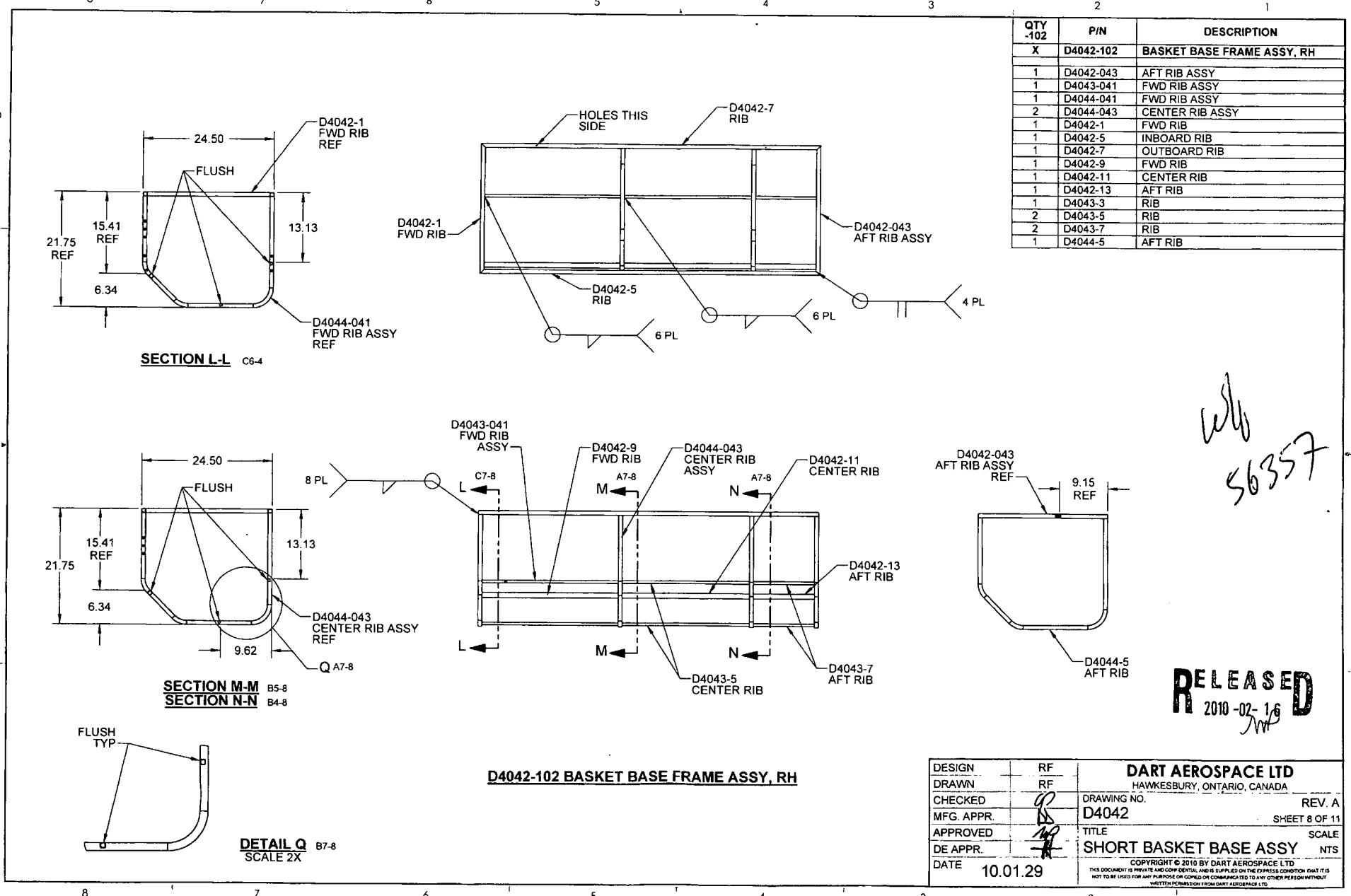












8

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6

5

4

3

2

1

ITEM	QTY 043	P/N	DESCRIPTION
	X	D4042-043	RIB AFT ASSEMBLY
1	1	D4042-3	AFT RIB
2	2	D4021-9	BUSHING

D4042-043 AFT RIB ASSEMBLY

RELEASED
2010-02-16
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.91 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>90</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MP</i>	D4042	SHEET 9 OF 11
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	SHORT BASKET BASE ASSY	
DATE	10.01.29	NTS	

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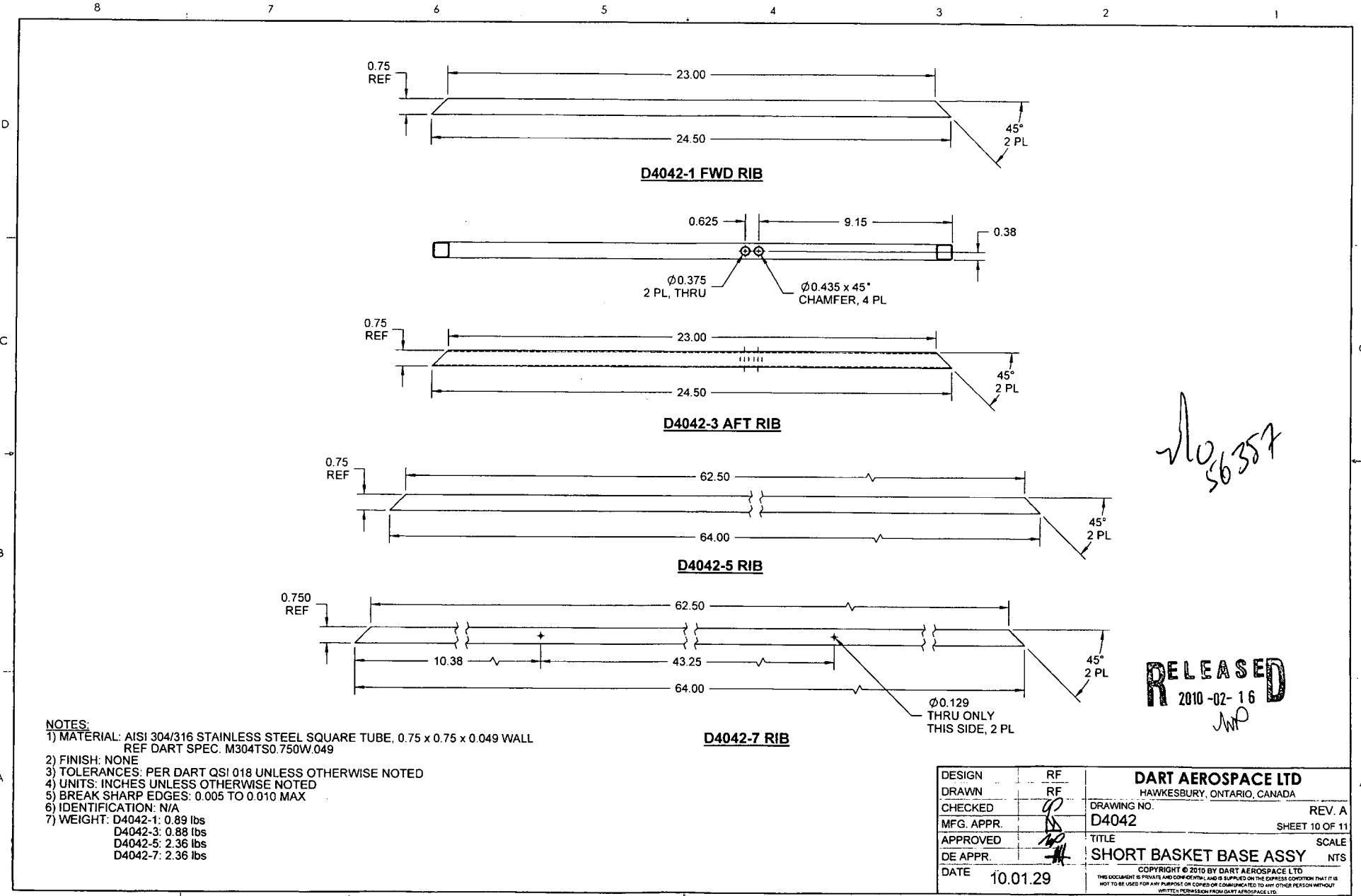
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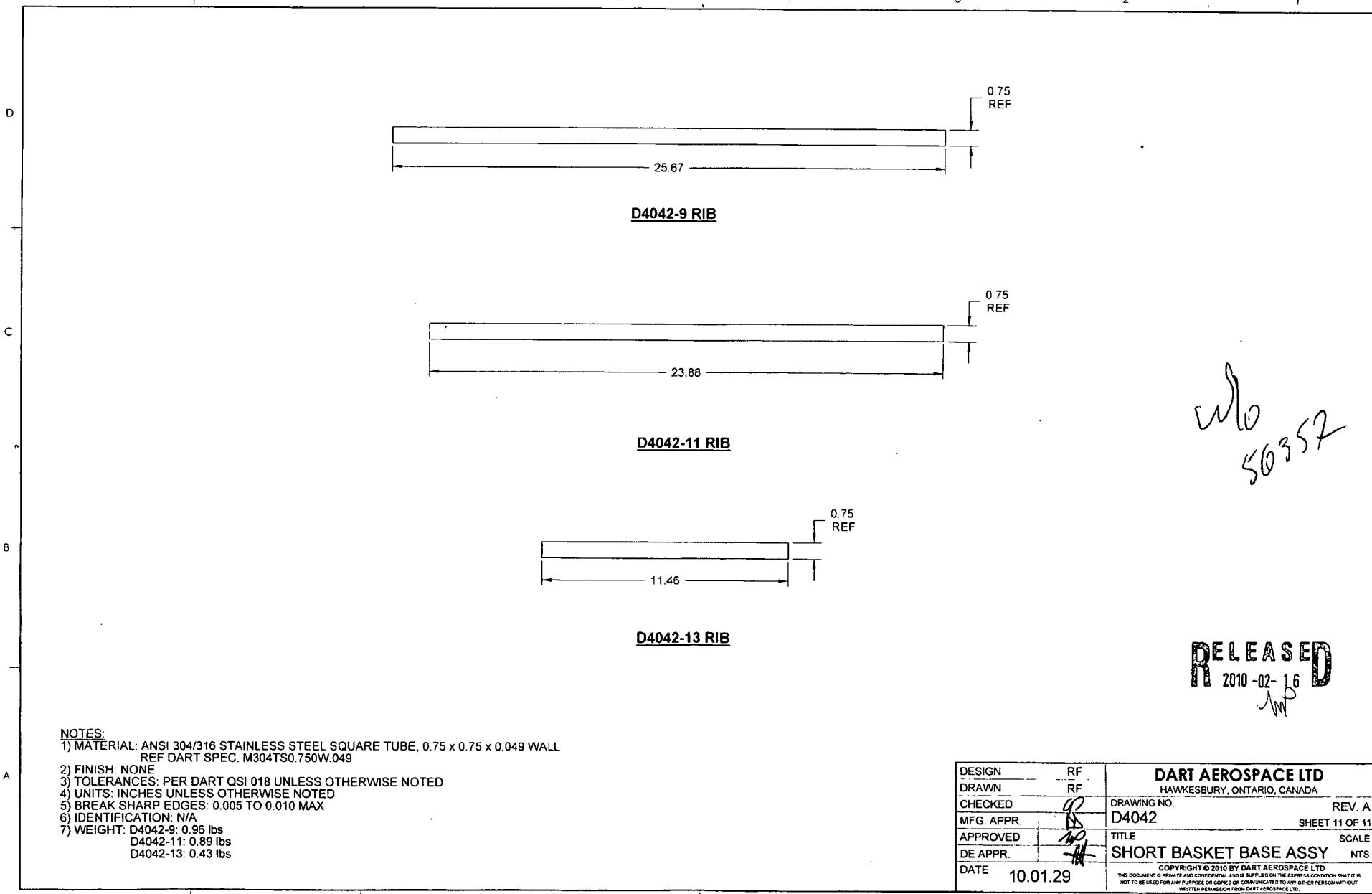
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